

Work Order ID 102698

June-11-13 12:49:52 PM

102698

Page 1

Item ID: D119-646-214

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Float Skidtube w/ Training Wearplates, RH

Stop *NS2*

Start Date: 6/11/13 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 6/25/13 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 13-06-11

Tooling:

Date:

Run Start *NR1*

QC: Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D119-646	B								MLJ 13-10-16
100		0.00							
100									
DC		0.00							
Document Control	Memo								
	Photocopy bluefile & type labels per PPP D119-646-214								
	CHG004								
	005 per ECN14-628								
110	Pick Kit	0.00							
110									
Packaging		0.00							
Packaging	Memo								
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC		0.00							
Quality Control									

DAS
31
9-89

13-10-21

DAS 9-89
33 13-10-16
9-89

DAS
31
9-89

13-11-14

B113665RRT1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 102698

June-11-13 12:49:53 PM

102698

Page 2

Item ID: D119-646-214

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Float Skidtube w/ Training Wearplates, RH

Start Date: 6/11/13 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 6/25/13 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D119-646-214								
	Location: <u>603</u>								
	PPP rev: <u>603</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

APR 29 2014 3:33

[Signature]

MLS

JUN 10 2015

ME
15-6-9

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 1

Work Order ID: 102698

102698

Parent Item: D119-646-214

D119-646-214

Parent Item Name: Float Skidtube w/ Training Wearplates, RH

Start Date: 6/11/13

Required Date: 6/25/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC
12.09.12 as per ECN12-644 DD verf:JLM
raise to chg003 (ECN 12-675) DD verf:JLM
chg004 (ECN 13-534) DD verf:JLM
IPP Rev:B
IPP REV:C 12.11.05
IPP REV:D 13.03.20 raise to

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D119-646-243		Manufactured	No			110	Each	0.0000	1	113605		12-11-13	
D119-646-243									**				DAS 6 9-89
Replacement Float Skidtube w/ Training Wearplates													
D119-646-311	9-89	Manufactured	No			110	Each	5.0000	1				
D119-646-311													DAS 31 9-89
Ground Handling													
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
	DAS 31 9-89			FG032			4						
					102218		4						
				FG125			1						
					99040		1						
D3883-2		Manufactured	No			110	Each	0.0000	2				
D3883-2	DAS 31 9-89												
Saddle, Outboard RH													
D3884-2		Manufactured	No			110	Each	1.0000	2				
D3884-2													
Saddle, Inboard RH													
	DAS 31 9-89			<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				ST431			1						
					53051		1						

1 113605

1 101768

2 102284

2 102198

13-10-16

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

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Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 2

Work Order ID: 102698

102698

Parent Item: D119-646-214

D119-646-214

Parent Item Name: Float Skidtube w/ Training Wearplates, RH

Start Date: 6/11/13

Required Date: 6/25/13

Start Qty: 1.00

Required Qty: 1.00

D2652

Manufactured No

110

Each

614.0000

16

16

D2652

Bushing

DAS
31
9-89

Location

Loc Qty

Loc Code

FG

44

31985

44

ST014

570

96451

170

98458

200

99029

200

AN3C50A

Purchased

No

110

Each

92.0000

8

8

AN3C50A

Bolt

DAS
31
9-89

Location

Loc Qty

Loc Code

ST354

92

123674

8

125389

29

125606

55

**
DAS
16
9-89

104848 JB
126293 (-1) 13-10-16
131263 SF

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Crosstube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Work Order ID: 102698

Parent Item: D119-646-214

Parent Item Name: Float Skidtube w/ Training Wearplates, RH

102698

D119-646-214

Start Date: 6/11/13

Required Date: 6/25/13

Start Qty: 1.00

Required Qty: 1.00

AN4C6A

Purchased

No

110

Each

1,414.000

18

18

DAS

33

9-89

AN4C6A

Bolt

DAS

31

9-89

Location

Loc Qty

Loc Code

FG

14

103344

4

121657

10

ST337A

1000

m125709

1000

ST355

32

122800

12

123900

6

124419

14

ST513

118

125388

118

ST516

250

124215

250

MS21250-05-006

Purchased

No

110

Each

256.0000

8

8

DAS

33

9-89

MS21250-05-006

BOLT

DAS

31

9-89

Location

Loc Qty

Loc Code

FG

10

124291

10

ST320

70

m125769

70

st507

26

125646

26

st510

75

125388

75

ST511

75

124751

75

June-11-13 12:49:58 PM

Shop Packet Print

Page 3

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

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Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General		
☐ Bending	☐ Bend	☐ Folio/Program	☐ Outside Dimensions
☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance
☐ Cracks	☐ Broken/Damage/Defect	☐ Hardware	☐ Part Incorrect
☐ Crimp/Kink/Ripple/Wave	☐ Burrs	☐ Inspection Incomplete/Unqualified	☐ Part Lost/Missing
☐ Cuffs	☐ Contamination	☐ Instructions Incomplete/Unclear	☐ Part Moved
☐ Crushing	☐ Countersink	☐ Misaligned/off center	☐ Positioned Wrong
☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Power Loss/Surge
☐ Inspection Strip in Tube	☐ Drawing	☐ Misread	☐ Pressure/Forced
☐ Marks/Chatter	☐ Drill Holes	☐ Off-set	☐ Set-up
☐ Turning Sequence	☐ Finish	☐ Out of Calibration	☐ Temperature/Cure
☐ Wave/Twist in Tube	☐ Fit/Function	☐ Out of Sequence	☐ Weld
			☐ Wrong Stock Pulled
			☐ Other

Picklist Print

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Page 4

Work Order ID: 102698

Parent Item: D119-646-214

Parent Item Name: Float Skidtube w/ Training Wearplates, RH

102698

D119-646-214

Start Date: 6/11/13

Required Date: 6/25/13

Start Qty: 1.00

Required Qty: 1.00

AN960C10L NAS1149C0332 Purchased No

110 Each 0.0000

AN960C10I

washer

AN960C416L NAS1149C0432 Purchased No

110 Each 0.0000

AN960C416I

WASHER

AN960C516L NAS1149C0532 Purchased No

110 Each 0.0000

AN960C516I

WASHER

MS21043-3 Purchased No

110 Each 1,589.000

MS21043-3

Nut

DAS
31
9-89

Location

Loc Qty

Loc Code

FG	80
103691	80
GA	106
123899	106
ST315	1403
123899	196
124555	1207

8 8
DAS
33
9-89
125654

30 30
DAS
33
9-89
126221

8 8
DAS
33
9-89
125484

8 8
DAS
33
9-89
126741

13-10-16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 5

Work Order ID: 102698

102698

Parent Item: D119-646-214

D119-646-214

Parent Item Name: Float Skidtube w/ Training Wearplates, RH

Start Date: 6/11/13

Required Date: 6/25/13

Start Qty: 1.00

Required Qty: 1.00

MS21043-4

Purchased

No

110

Each

2,147.000

13

13

DAS
33
9-89

MS21043-4

Nut

DAS
31
9-89

Location

Loc Qty

Loc Code

FG	36	
104603	36	
GA	2	
121652	2	
ST315	2109	
121162	25	
123021	3	
123525	29	
123900	2	
125654	1112	
m125807	938	

DAS
33
9-89

D2712

Manufactured

No

110

Each

1,002.000

12

12

DAS
33
9-89

D2712

Set Screw

DAS
31
9-89

Location

Loc Qty

Loc Code

FG	50	
29962	50	
ST016	952	
101775	250	
102226	250	
91229	12	
93686	340	
99794	100	

DAS
33
9-89

125907

102226

13-10-16

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Shop Packet Print

Page 5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 6

Work Order ID: 102698

Parent Item: D119-646-214

Parent Item Name: Float Skidtube w/ Training Wearplates. RH

102698

D119-646-214

Start Date: 6/11/13

Required Date: 6/25/13

Start Qty: 1.00

Required Qty: 1.00

D3672-7
Phenolic Washer

DAS
31
9-89

Manufactured No

110

Each

1,214.000

24 24

DAS
33
9-89

Location

Loc Qty

Loc Code

FG	25	
93370	25	
ST062	1189	
101752	500	
81872	20	
91617	8	
93370	161	
96588	500	

110

Each

1,635.000

30 30

DAS
33
9-89

13-10-16

Location

Loc Qty

Loc Code

FG	111	
84432	11	
89273	100	
FP-001	127	
91915	127	
ST061	897	
86517	5	
88441	25	
91915	140	
93316	10	
93925	509	
99155	208	
ST062	500	
101707	500	

D3672-3

D3672-3
Phenolic Washer

DAS
31
9-89

Manufactured No

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Page 6

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 7

Work Order ID: 102698

Parent Item: D119-646-214

Parent Item Name: Float Skidtube w/ Training Wearplates, RH

102698

D119-646-214

Start Date: 6/11/13

Required Date: 6/25/13

Start Qty: 1.00

Required Qty: 1.00

D3407-041

Manufactured No

110

Each

22.0000

1

DAS

D3407-041

Tow Ring

DAS
31
9-89

Location

Loc Qty

Loc Code

ST463

22

100298

1

88213

3

98924

12

99295

6

*DAS
31
9-89

108254

DAS
33
9-89

D3417-5

Manufactured No

110

Each

125.0000

1

DAS

D3417-5

Washer

DAS
31
9-89

Location

Loc Qty

Loc Code

ST044

125

101726

46

93816

54

99017

24

99762

1

*DAS
31
9-89

93816

DAS
33
9-89

D3456-1

Manufactured No

110

Each

193.0000

1

DAS

D3456-1

Washer

DAS
31
9-89

Location

Loc Qty

Loc Code

FG

7

25701

7

ST047

186

80252

1

89237

6

96570

21

99338

158

*DAS
31
9-89

106784

DAS
33
9-89

12-10-16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID: 102698

102698

Parent Item: D119-646-214

D119-646-214

Parent Item Name: Float Skidtube w/ Training Wearplates, RH

Start Date: 6/11/13

Required Date: 6/25/13

Start Qty: 1.00

Required Qty: 1.00

D3417-7

Manufactured No

110

Each

90.0000

DAS

33

9-89

D3417-7

Washer

DAS

31

9-89

Location

ST045

Loc Qty

90

60

30

102368

91553

110

Each

0.0000

Loc Code

6 6

AN960JD416

NAS1149D0463J Purchased

No

AN960JD416

Washer

DAS

31

9-89

DAS

33

9-89

13-10-16

91553

126221

**

DAS
31
9-89

DSI 9685-011 x 1 129381
per ECU 14.628
u

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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8 13-10-21

4.3 Float Skidtubes

Item	Qty -013	Qty -014	Qty -113	Qty -114	Qty -213	Qty -214	Qty -043	Qty -143	Qty -153	Qty -243	Qty -253	Qty -311	Part Number	Description
	X												D119-646-013	FLOAT SKIDTUBE INSTALLATION WITH WEARPADS, LH
		X											D119-646-014	FLOAT SKIDTUBE INSTALLATION WITH WEARPADS, RH
			X										D119-646-113	FLOAT SKIDTUBE INSTALLATION WITH FULL LENGTH WEARPLATES & WEARPADS, LH
				X									D119-646-114	FLOAT SKIDTUBE INSTALLATION WITH FULL LENGTH WEARPLATES & WEARPADS, RH
					X								D119-646-213	FLOAT SKIDTUBE INSTALLATION WITH TRAINING WEARPLATES, LH
						X							D119-646-214	FLOAT SKIDTUBE INSTALLATION WITH TRAINING WEARPLATES, RH
							X						D119-646-043	REPLACEMENT FLOAT SKIDTUBE WITH WEARPADS
	1	1						X					D119-646-143	REPLACEMENT FLOAT SKIDTUBE WITH FULL LENGTH WEARPLATES & WEARPADS
			1	1					X				D119-646-153	WEARPLATE KIT STANDARD SKIDTUBE
					1	1				X			D119-646-243	REPLACEMENT FLOAT SKIDTUBE WITH TRAINING WEARPLATES
											X		D119-646-253	TRAINING WEARPLATES FLOAT SKIDTUBE
												X	D119-646-311	GROUND HANDLING KIT
1	1	1	1	1	1	1	1						D3905-041	FLOAT SKIDTUBE ASSY. WITH WEARPAD
20								1					D3905-043	FLOAT SKIDTUBE ASSY. WITH WEARPLATE & WEARPAD
24									1				D3846-1	GASKET
25									1				D3846-11	GASKET
26									1				D3847-043	FWD WEARPLATE ASSY
27									1				D3847-045	CENTER WEARPLATE ASSY
28									1				D3847-049	AFT WEARPLATE ASSY
29									8				D3847-1	WEARPAD
30									1				D3847-11	WEARPAD
31									42				AN3C5A	BOLT
32									42				AN960C10L	WASHER (OR NAS1149C0332R)
40										1			D3905-045	FLOAT SKIDTUBE ASSY. TRAINING WEARPLATE
44											1		D3849-047	FWD TRAINING WEARPLATE ASSY
45											1		D3849-045	AFT TRAINING WEARPLATE ASSY
46											1		D3846-1	GASKET
47											1		D3846-11	GASKET
48											1		D3847-1	WEARPAD
49											1		D3847-11	WEARPAD
51											16		D3904-1	WASHER
52											8		AN3C46A	BOLT
53											8		MS21043-3	NUT
54											10		AN3C5A	BOLT
55											10		AN960C10L	WASHER (OR NAS1149C0332R)
60	2		2		2	2							D3883-1	SADDLE, OUTSIDE, LH
61		2		2		2							D3883-2	SADDLE, OUTSIDE, RH
62	2		2		2	2							D3884-1	SADDLE, INSIDE, LH
63		2		2		2							D3884-2	SADDLE, INSIDE, RH
64	16	16	16	16	16	16							D2652	BUSHING
65	8	8	8	8	8	8							AN3C50A	BOLT
66	12	12	12	12	12	12							AN4C6A	BOLT
67	8	8	8	8	8	8							MS21250-05006	BOLT
68	8	8	8	8	8	8							AN960C10L	WASHER (OR NAS1149C0332R)
69	24	24	24	24	24	24							AN960C416L	WASHER (OR NAS1149C0432R)
70	8	8	8	8	8	8							AN960C516L	WASHER (OR NAS1149C0532R)

Item	Qty -013	Qty -014	Qty -113	Qty -114	Qty -213	Qty -214	Qty -043	Qty -143	Qty -153	Qty -243	Qty -253	Qty -311	Part Number	Description	
					8	8							MS21043-3	NUT	
					12	12							MS21043-4	NUT	
71	8	8	8	8	12	12							D2712	SET SCREW	
72	12	12	12	12	12	12							D3672-7	WASHER	
73	12	12	12	12	16	16							D3672-3	WASHER	
74	16	16	16	16	24	24							D3672-7	WASHER	
75	24	24	24	24	8	8									
76	8	8	8	8	1	1							D3407-041	TOW RING	
					1	1							D3417-5	WASHER	
80	1	1	1	1	1	1							D3456-1	WASHER	
81	1	1	1	1	1	1							MS21043-4	NUT	
82	1	1	1	1	1	1							D3417-7	WASHER	
83	1	1	1	1	1	1									
84	1	1	1	1									2	D3886-041	LUG ASSEMBLY
													8	D2652	BUSHING
90													4	AN3C46A	BOLT
91													4	AN960C10L	WASHER (OR NAS1149C0332R)
92													4	MS21043-3	NUT
93															
94															
														AN3C45A	BOLT
														AN3C50A	BOLT
100	3	3	3	3	(3)	(3)								AN3C45A	BOLT
101														AN3C46A	BOLT
102	3	3	3	3	(3)	(3)								D3904-1	WASHER
103					(9)	(9)								AN4C6A	BOLT
104														D3672-3	WASHER
105	6	6	6	6	6	6								AN960C416L	WASHER (OR NAS1149C0432R)
106	6	6	6	6	6	6								AN960JD416	WASHER (OR NAS1149C0463J)
107	6	6	6	6	6	6								AN960C10L	WASHER (OR NAS1149C0332R)
108	6	6	6	6	(3)	(3)								MS21043-3	NUT
109	12	12	12	12	(6)	(6)									
110	6	6													

PACKETS ARE REF. ONLY AND DO NEED TO BE INCLUDED WITH KIT.

() ITEMS IN BRACKETS ARE REF. ONLY AND DO NEED TO BE INCLUDED WITH KIT.
AS THEY ARE ALREADY INSTALLED ON SKIDTUBE.